

Work Order ID 67763

Wednesday, March 30, 2011 10:34:16 AM



Page 1

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/30/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 100.00

Customer:

Reference:

Approvals:

Process Plan:

M

Date: 11/03/31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00



BAND SAW

Bandsaw

Memo

0.00

~~Jeaspa Bandsaw~~

Cut D2423 extrusion to 0.82"

Batch:

Cut @ 4 meter

CY 11/03/31

110

0.00



HAAS CNC VERTICAL MACHINING #1

~~HAAS Purchasing~~
HAAS CNC vertical machine #1

Memo

0.00

1-Machine per folio FA927

FOLIO REV:

DWG REV:

Check for crack while loading into the machine.

2- deburr

P/O: 13761

Issue P/O to 4 meter

machine as per dwg D2230 REV.G

CY 11/03/31 100

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2230-3

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Item Name: Lug

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Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC
Quality Control

~~QC2- Inspect parts off machine FAI/FAIB~~

0.00

Memo

0.00

*rec'd + inspect for transit damage
+ attached C of C to W/O*

6/11/11 (100)

130



QC
Quality Control

~~QC6~~ Inspect parts - second check

0.00

Memo

0.00

8.10.10.08

*counts
7.10.10*

150



HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

x100 d 11/04/11

W/O:		WORK ORDER CHANGES					
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Page 3

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Revision ID:

Stop



Item Name: Lug

Start Date: 3/30/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

100 BL 11-4-11.

170

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

M116 964

Memo

0.00

Powder Coating

START TIME: 1:10
OVEN TEMPERATURE: 320°
FINISH TIME: 1:40

100 BL 11-4-11.

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/4/11 100

Dart Aerospace Ltd

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Page 4

Item ID: D2230-3

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Item Name: Lug

Start Date: 3/30/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

190

Identify as per dwg & Stock Location: 425

0.00



Packaging

Memo

0.00

Packaging

11/4/11 50 120 5

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/04/12 12

11/04/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 10:34:21 AM

Page 1

Work Order ID: 67763

Parent Item: D2230-3

Parent Item Name: Lug





Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC
25 JLM VERIFIED BY:EC
☐ IPP REV :E NEW FOLIO # 10-05-


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			100	f	384.5000	0.0683	7.189474			
												02 11/03/31	

Location	Loc Qty	Loc Code
MAT006	384.5	
43722	161.5	
45800	1	
63005	222	

7.19

D2230-3P

x100

 4/4/11 (100)

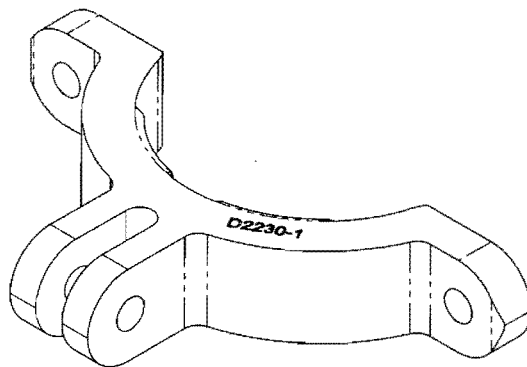
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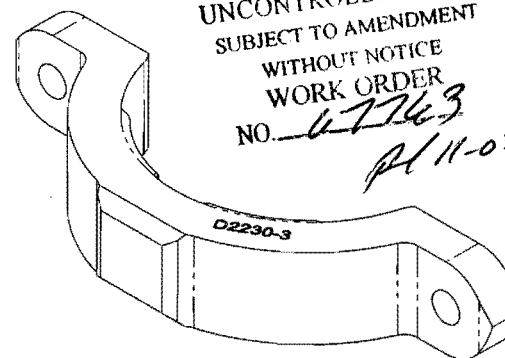
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NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67763
PI 11-03-30

RELEASED
[Signature]



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005 .
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
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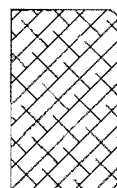
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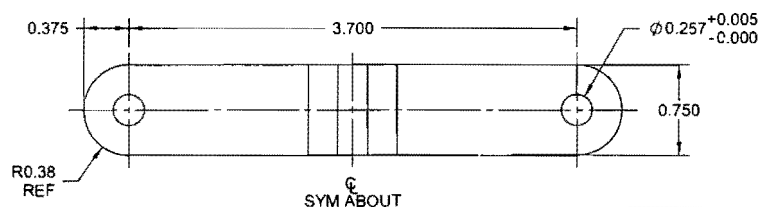
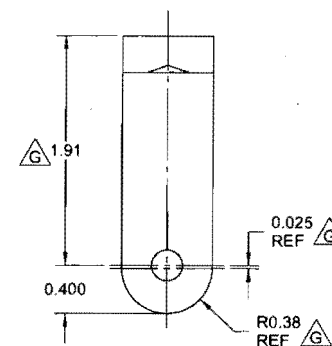
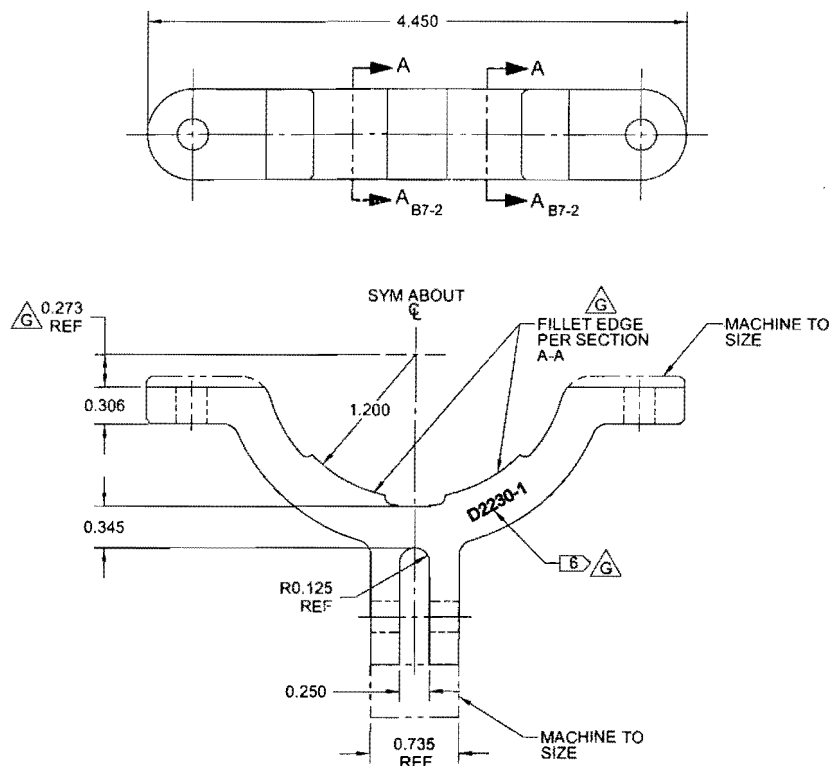
NOTE: Date & initial all entries

u1067743

SECTION A-A D4-2
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

RELEASED
09/06/25 M

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		MOUNTING LUG	SCALE
DE APPR.			NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

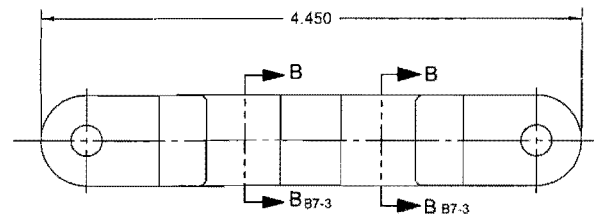
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

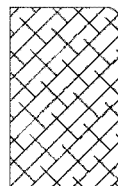
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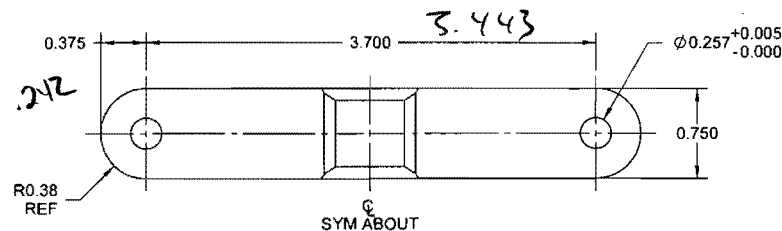
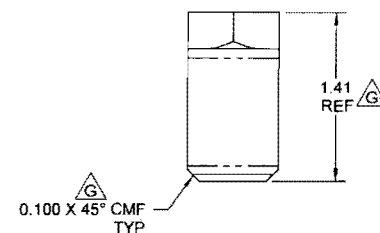
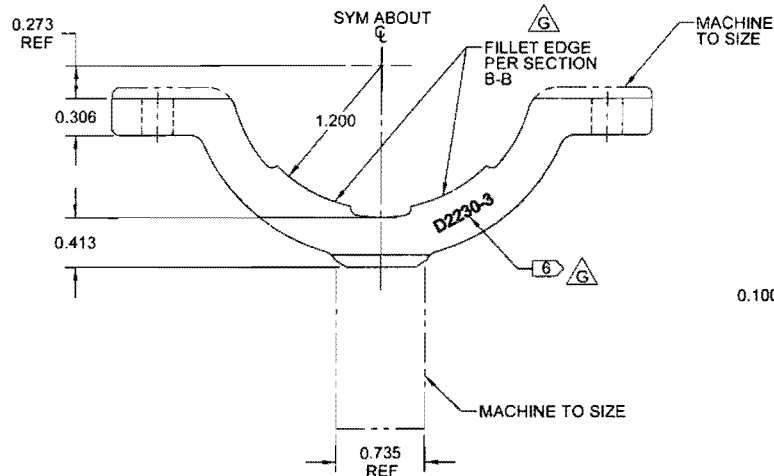
NOTE: Date & initial all entries



who 47743



SECTION B-B D4-3
SCALE 2X
R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/04/2016

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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Dart Aerospace Ltd

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13761

Purchase Order Date 3/31/2011
PO Print Date 3/31/2011

Page Number 1 of 1

Order From : VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
C/L 11/03/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-1P	LUG	4/8/2011 Yes	✓ 100.00 Each	Dart Truck	\$19.9500	\$1,995.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B67761				
2	D2230-3P	LUG	4/8/2011 Yes	100.00 Each	Dart Truck	\$13.6000	\$1,360.00
		Special Inst:	AS PER DWG D2230 REV. G B67763				
PO Total:							\$3,355.00

CERTIFICATE OF CONFORMITY
REC'D UPON DELIVERY

required ASAP
please thanks
Chantal

Change Nbr: 1 Change Date: 3/31/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17878

Date:

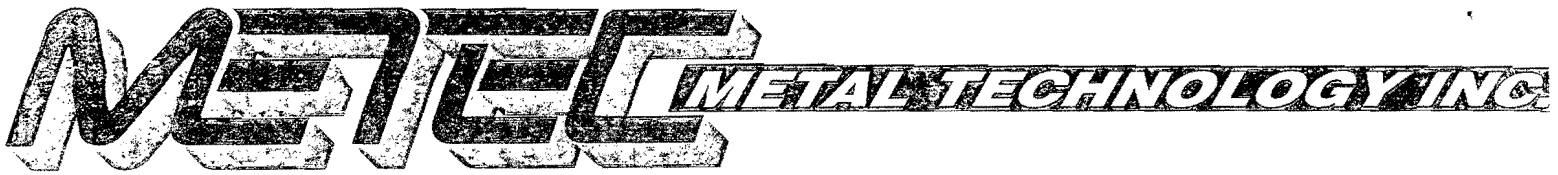
Apr 08, 2011

Page:

1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13761	Sold By: Walz, Christian D.
Shipped By:	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		
D2230-3 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	100	
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

100

D2230-3

Mounting Lug

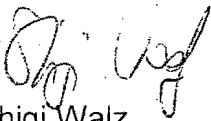
S. 1/04/08

13761

MATERIAL: supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, April 8, 2011

